

GC77 1146

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD

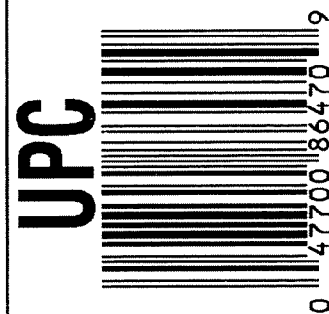


ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6771146



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 677 1146

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-31-08	SPD
430	ASSEMBLE TO STOCK		7-31-08	SP
440	PROOF		7-31-08	SPD
460	CHECK HEADSPACE		7-31-08	SPD
470	DIS-ASSEMBLE ACTION		7-31-08	SPD
472	SERIALIZE BOLT HANDLE		8-1-08	SPD
475	DRILL AND TAP SIGHT HOLES	MAGNA - FLUX AUG 09 2008	8-5-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR BK	8-6-08	BK
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/4/08	RT
520	GOFF BLAST BBL / REC		8/2/08	SPD
542	APPLY COATINGS (BARREL ACTION)		8/6	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-18-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-18-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-18-08	SP
	D) OIL FIRING PIN ASSEMBLY		8-25-08	PSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

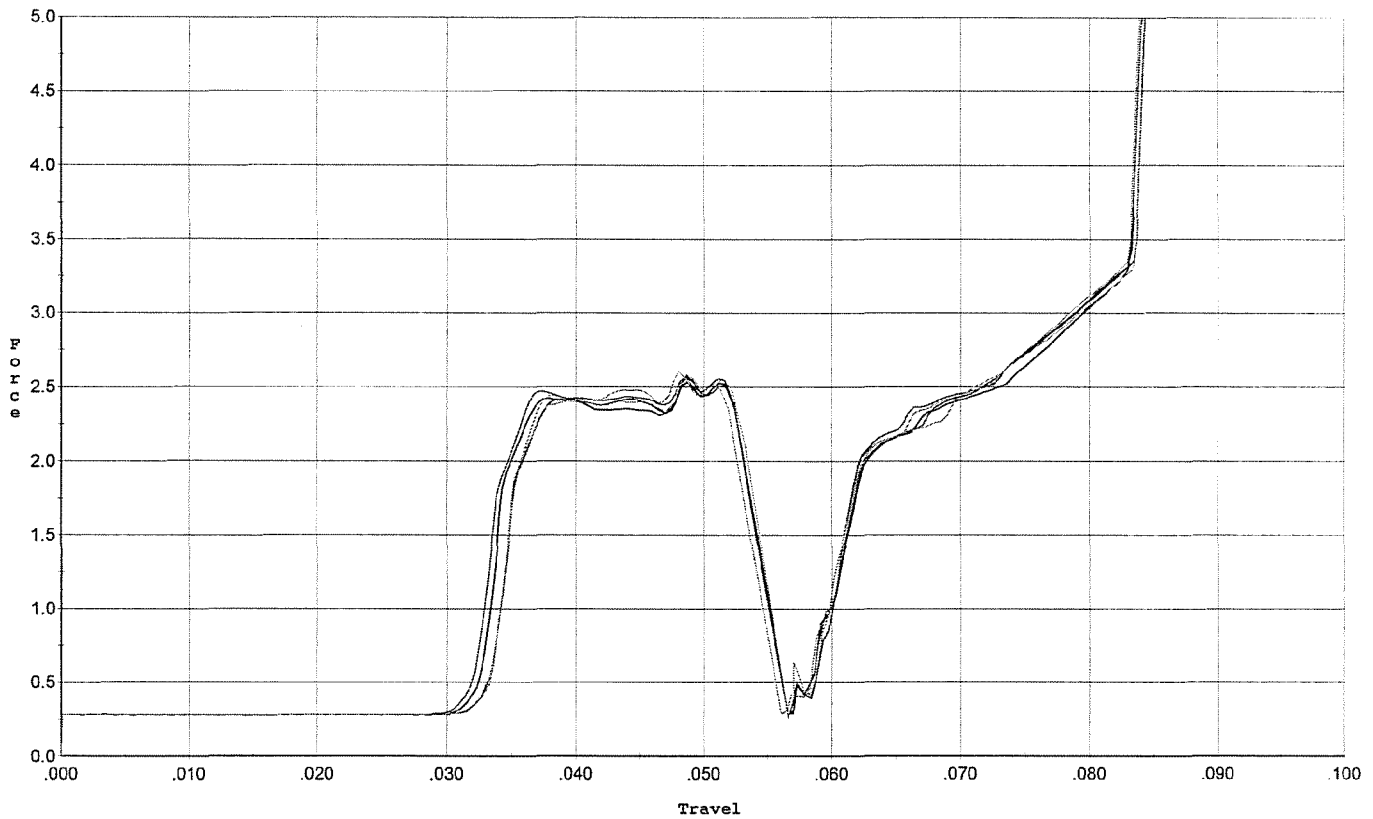
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.0</u> <u>2.5</u> <u>2.0</u>	9.4.08	BSN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.5</u>	9.4.08	PSW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.023</u>	9.4.08	PSW
	J) ASSEMBLE STOCK		8.25.08	PSW
	K) ASSEMBLE SWIVEL STUDS		9.4.08	PSW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-26-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	8-26-08	Fm
660	INSPECT FOR LIVE AMMO		8-26-08	TL
670	FINAL INSPECTION A) HEADSPACE		9.4.08	BSN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.34</u> <u>2.32</u> <u>2.27</u> <u>2.24</u> <u>2.24</u>	9-3-08	BSH.
	C) FUNCTION		9.4.08	PSW
690	PACK		9-5-08	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.Putch 8/15/08

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. ini. +/- .50 lbs.



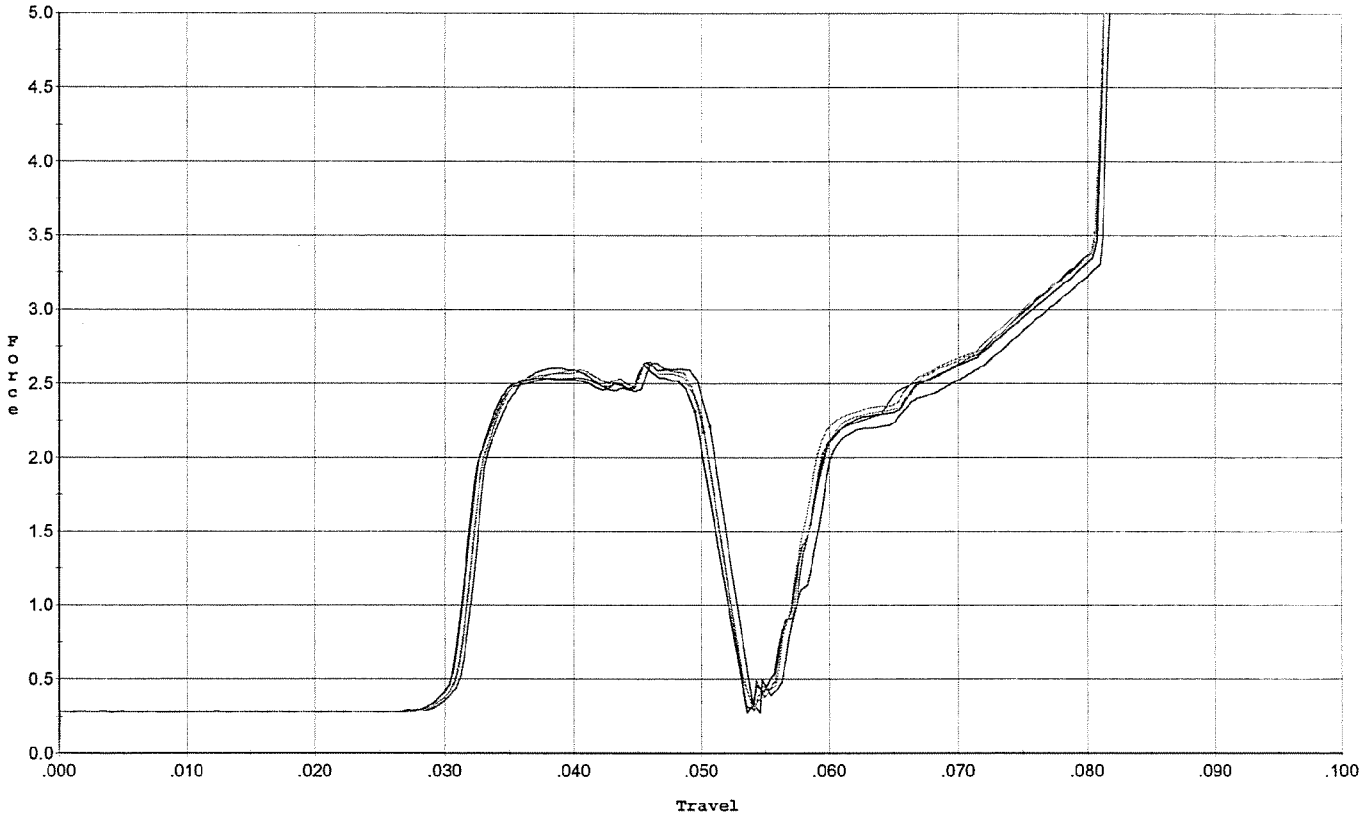
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.574	0.054	0.033	0.035	0.056		Set Trigger
2	2.535	0.054	0.032	0.035	0.057		Set Trigger
3	2.566	0.052	0.032	0.035	0.057		Set Trigger
4	2.585	0.053	0.033	0.035	0.056		Set Trigger
5	2.609	0.054	0.033	0.035	0.055		Set Trigger

Avg 2.57

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.Putch 8/15/08

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. after 50 cycles +/- .50 lbs.



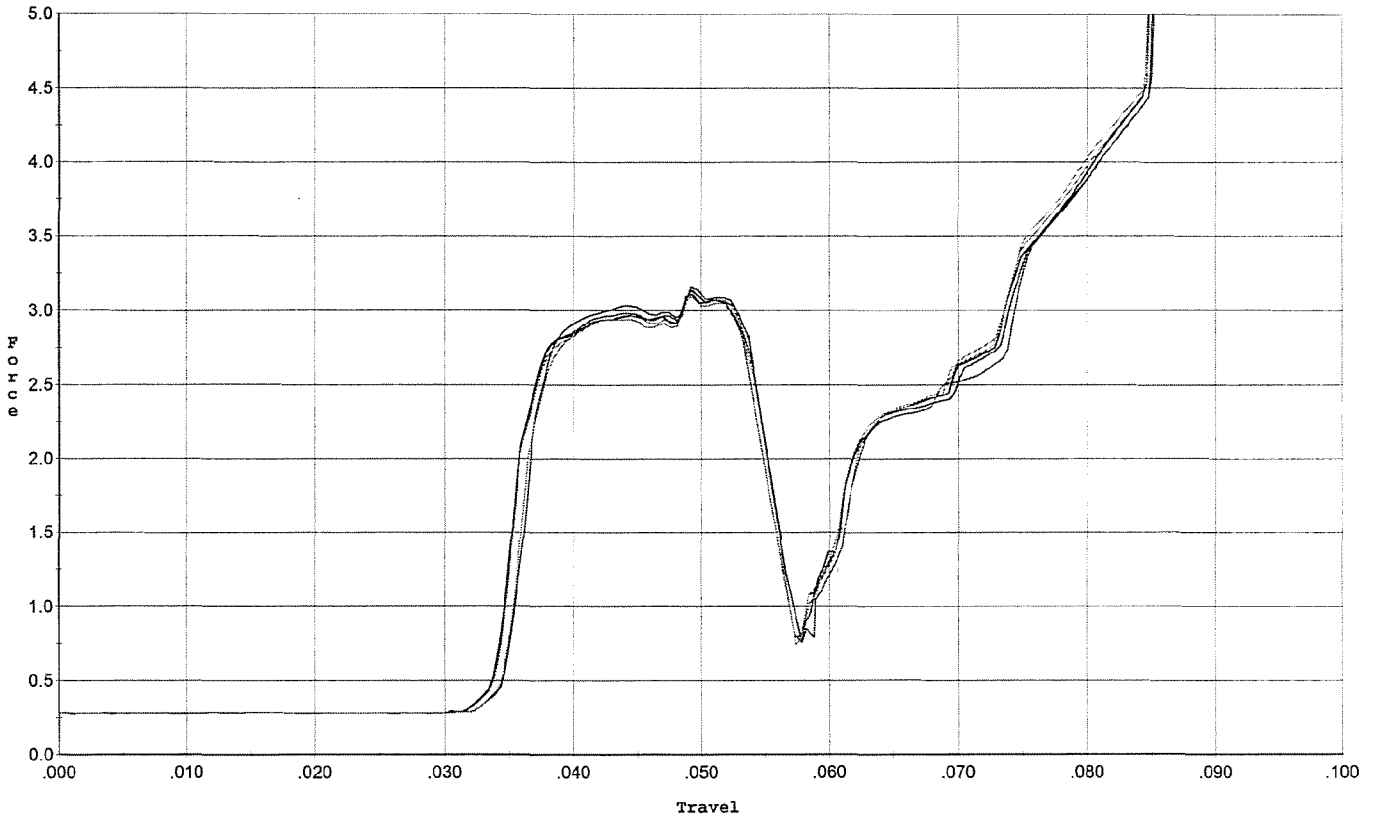
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.638	0.051	0.031	0.034	0.056		Set Trigger
2	2.626	0.049	0.031	0.034	0.054		Set Trigger
3	2.639	0.050	0.031	0.034	0.055		Set Trigger
4	2.636	0.050	0.031	0.034	0.055		Set Trigger
5	2.645	0.050	0.031	0.034	0.055		Set Trigger

Avg 2.63

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.Putch 8/15/08

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. ini. +/- .75 lbs.



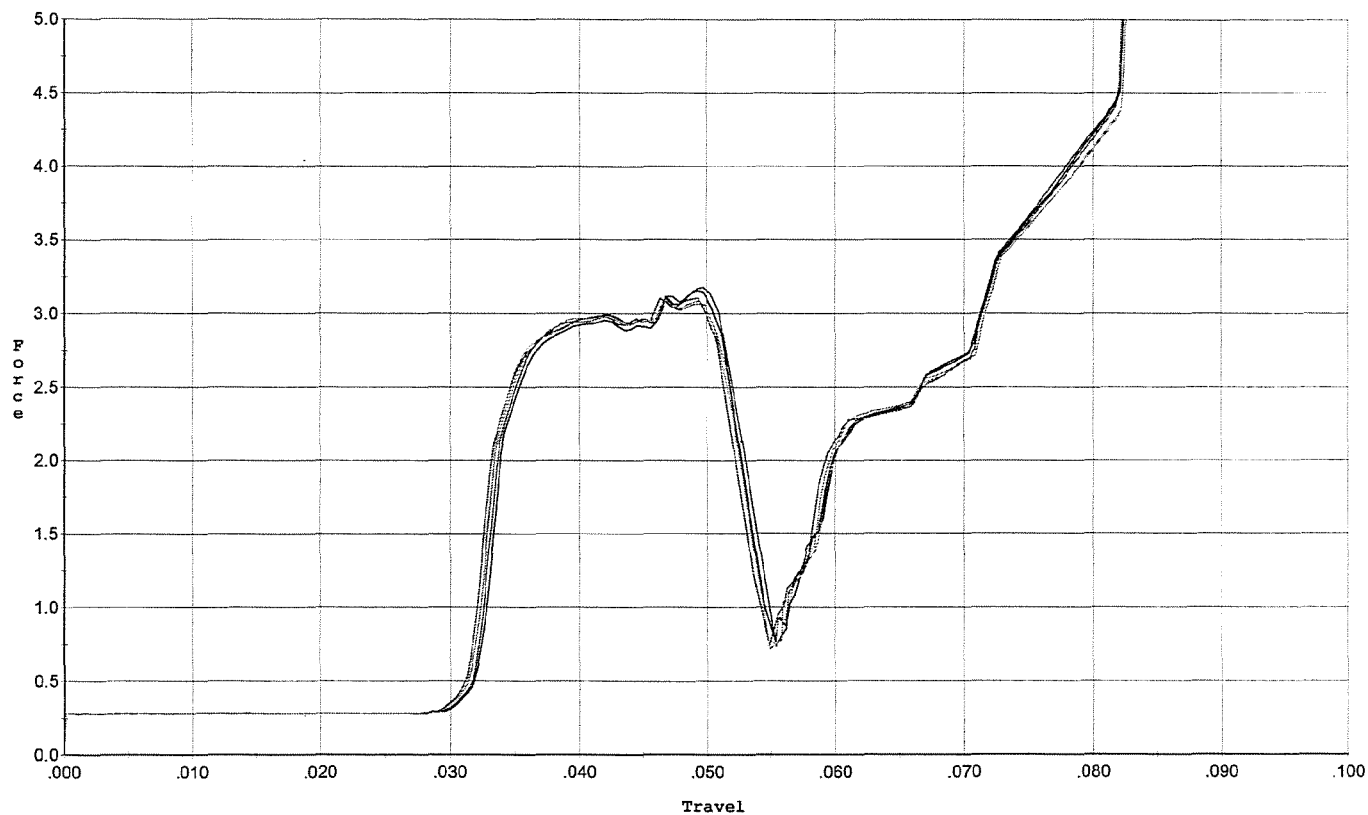
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.158	0.054	0.035	0.035	0.064		Set Trigger
2	3.109	0.053	0.034	0.035	0.064		Set Trigger
3	3.142	0.054	0.034	0.035	0.066		Set Trigger
4	3.129	0.054	0.034	0.035	0.065		Set Trigger
5	3.093	0.053	0.034	0.035	0.062		Set Trigger

AVG 3.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.Putch 8/15/08

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



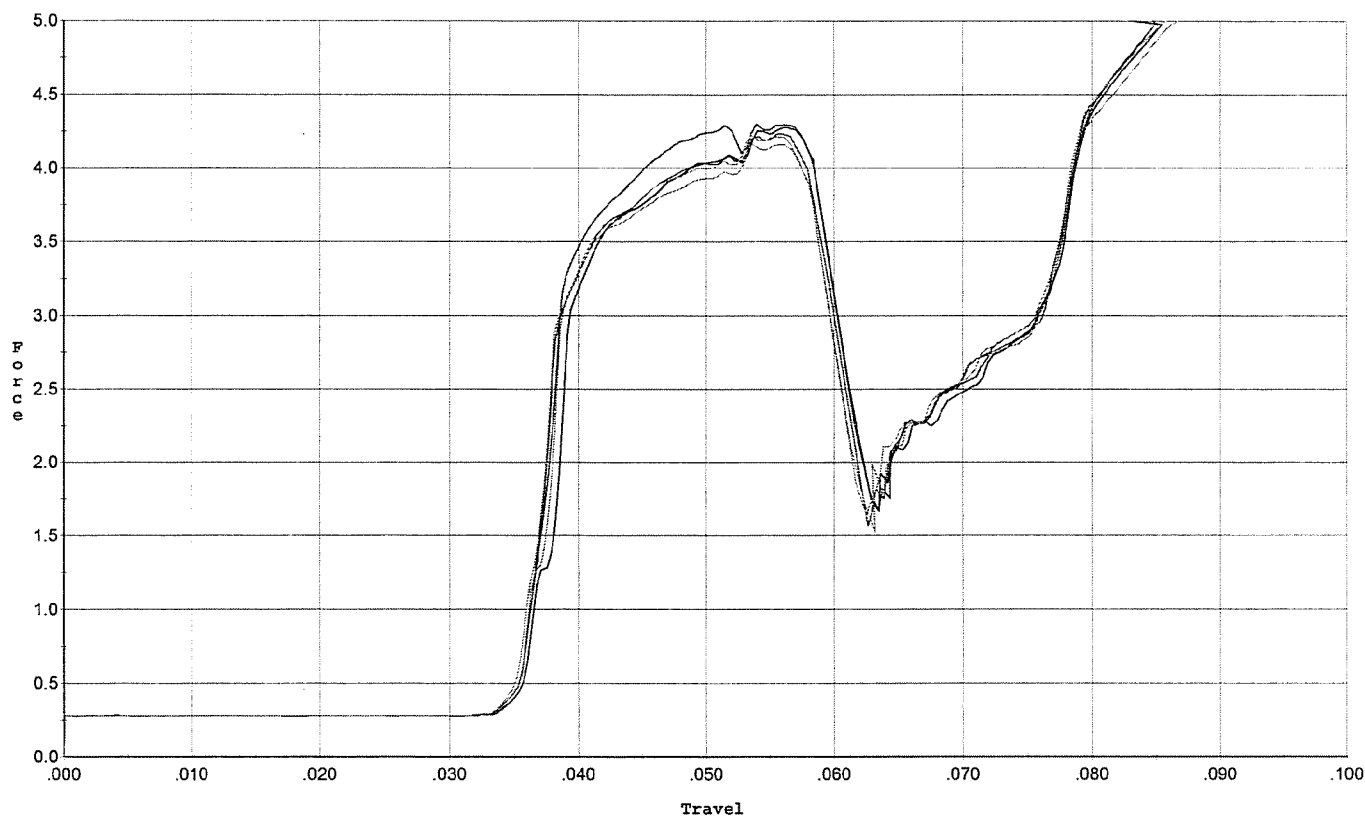
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.177	0.053	0.032	0.033	0.066		Set Trigger
2	3.156	0.051	0.032	0.034	0.063		Set Trigger
3	3.105	0.051	0.031	0.034	0.063		Set Trigger
4	3.099	0.052	0.031	0.034	0.065		Set Trigger
5	3.086	0.052	0.031	0.034	0.064		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.Putch 8/15/08

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



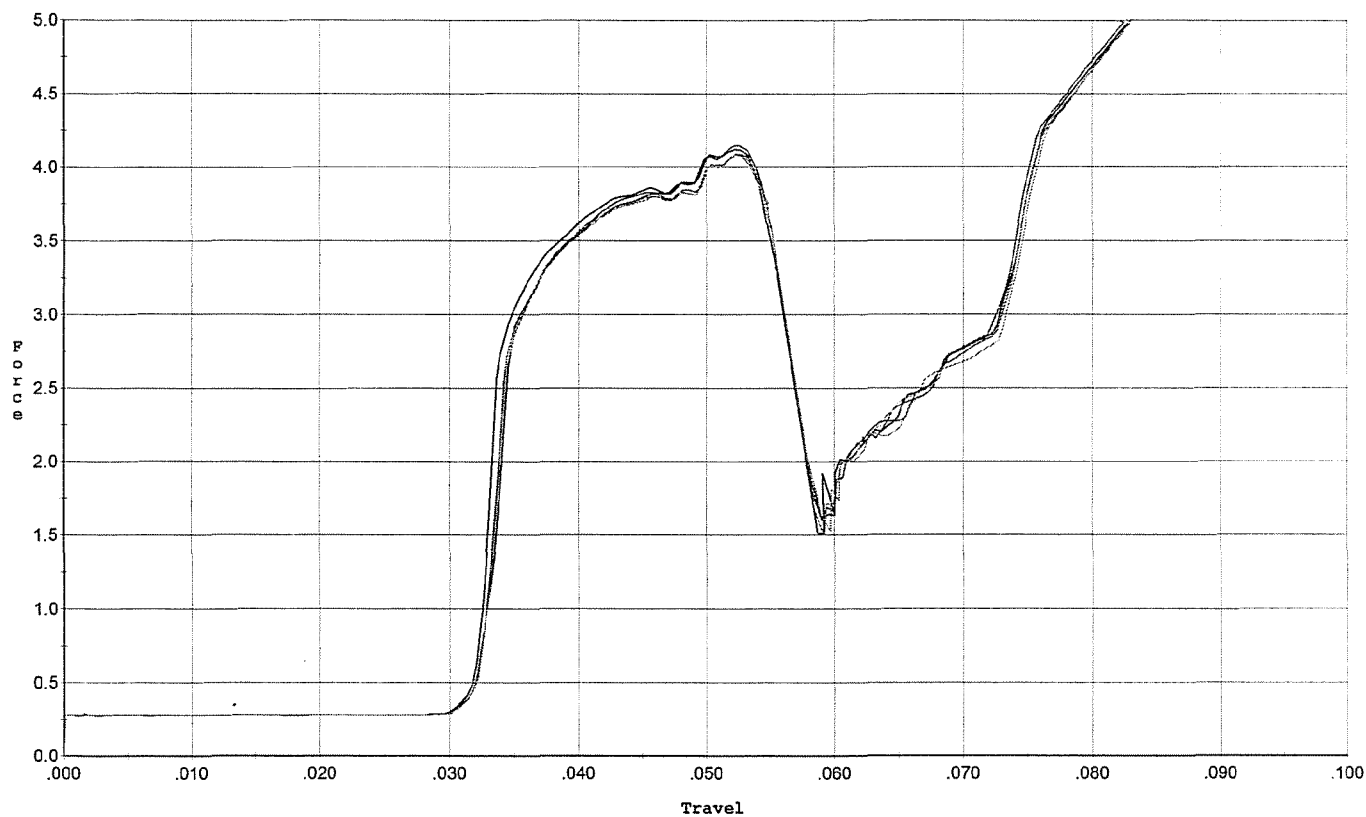
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.299	0.058	0.035	0.034	0.098		Set Trigger
2	4.275	0.058	0.036	0.034	0.093		Set Trigger
3	4.231	0.060	0.036	0.034	0.097		Set Trigger
4	4.223	0.058	0.035	0.034	0.094		Set Trigger
5	4.162	0.058	0.035	0.034	0.092		Set Trigger

Avg 4.23

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.Putch 8/15/08

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



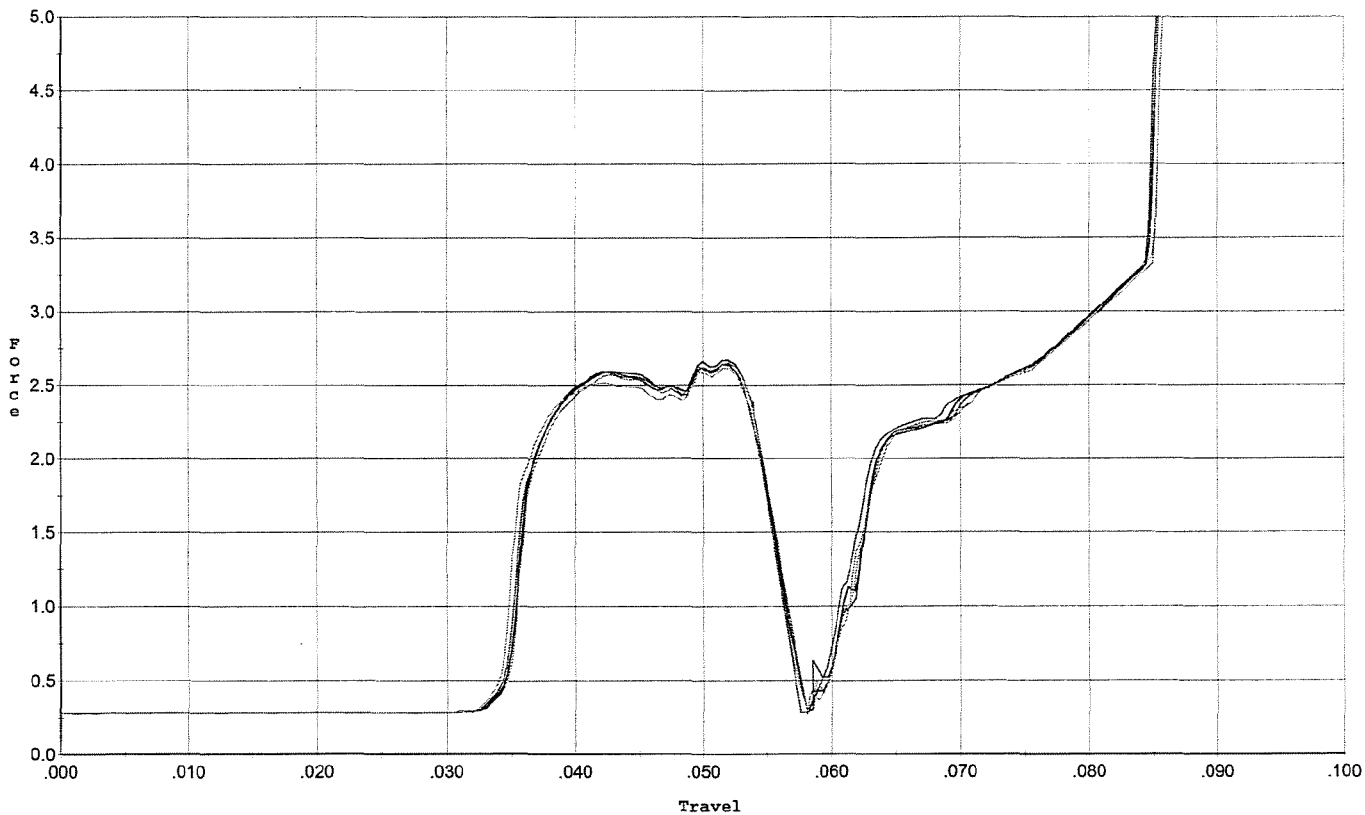
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.146	0.055	0.032	0.033	0.090		Set Trigger
2	4.123	0.055	0.032	0.033	0.093		Set Trigger
3	4.087	0.055	0.032	0.033	0.090		Set Trigger
4	4.082	0.055	0.032	0.033	0.090		Set Trigger
5	4.083	0.055	0.032	0.033	0.090		Set Trigger

Avg 4.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.Putch 8/15/08

Model: M/24
Serial No: Form #F005
Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



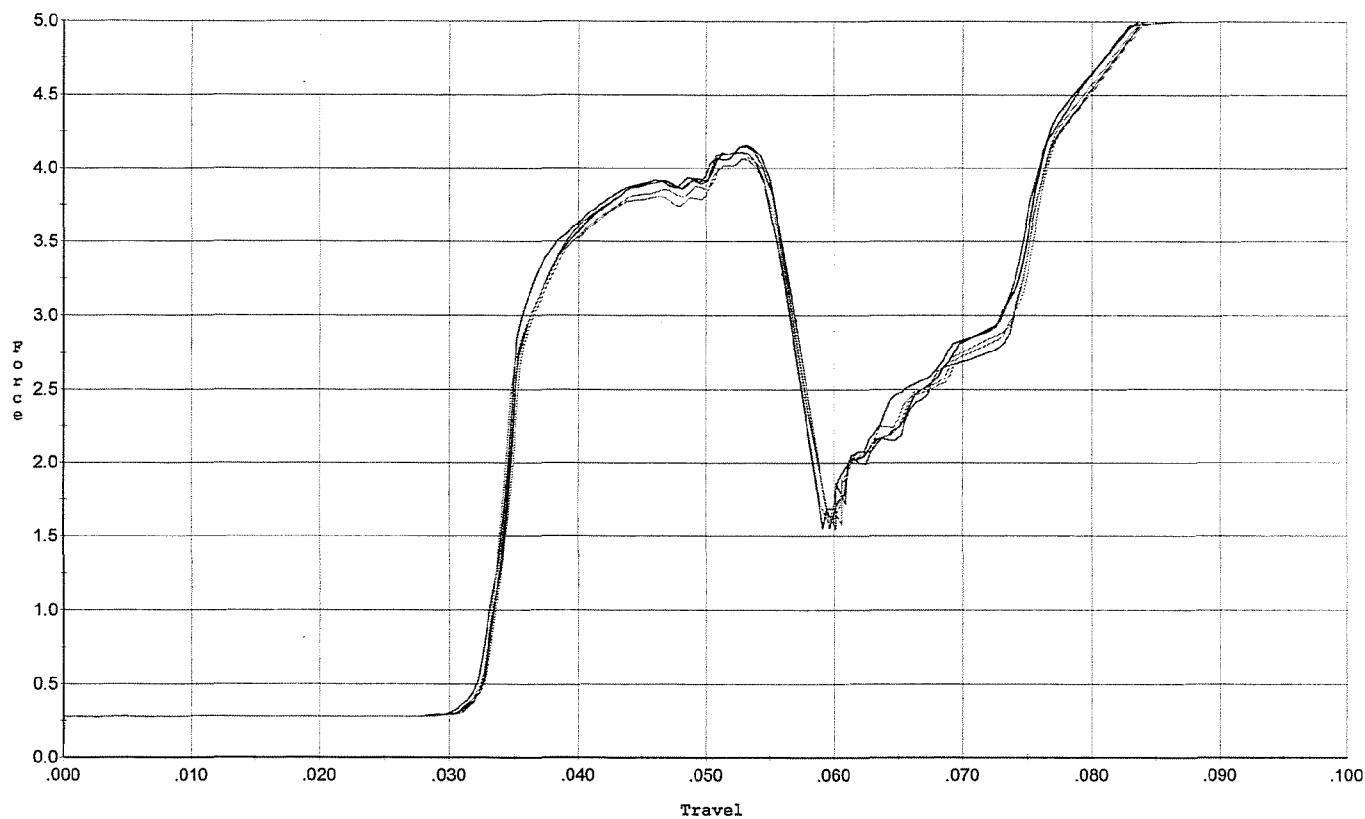
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.647	0.054	0.034	0.036	0.057		Set Trigger
2	2.671	0.054	0.035	0.036	0.057		Set Trigger
3	2.640	0.054	0.034	0.035	0.057		Set Trigger
4	2.618	0.054	0.034	0.035	0.057		Set Trigger
5	2.653	0.056	0.035	0.036	0.058		Set Trigger

Avg 2.64

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.Putch 8/15/08

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.109	0.056	0.032	0.033	0.093		Set Trigger
2	4.157	0.057	0.032	0.033	0.094		Set Trigger
3	4.146	0.055	0.033	0.034	0.090		Set Trigger
4	4.071	0.057	0.032	0.034	0.093		Set Trigger
5	4.068	0.055	0.032	0.033	0.090		Set Trigger

Avg 4.11